

Date: Thursday, 8/24/2006 11:11:44 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER BUSHING
Job Number : 28334	
Estimate Number : 10823	
P.O. Number : N/A	Part Number : D23271
This Issue : 8/24/2006 S.O. No. : N/A	Drawing Number : D2327 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : C
Previous Run : 26742	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 8/31/2006
Checked & Approved By : <u>[Signature] 06.08.24</u>	Qty: 50 Um: Each
Comment : Est. D 05.14.02 Removed 303 SS KJ/EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304R0375	304 SS ROUND BAR
-----	-----------	------------------



Comment: Qty.: 0.1860 f(s)/Unit Total: 9.2978 f(s) M18993 (M304R0375 W65) 3.348 ft  
 Inventory  
 Material: AISI 304 Round Bar Ø0.375"  
 (M304R0.375) Batch: M100255 5.952 ft 06/08/25 50

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL  
 Turn per Folio FA232 and Dwg D2327  
 Deburr

[Signature]

06.08.25

50

PTO

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RG 06.08.26

50

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.G 06/08/28


50

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: ST31

[Signature] 06/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-08-26	2	Mat'l missing to complete w/o. 304ss tubing used instead M304 TR 0.375 w. 065 ID opened up to .257' diam. 250"	BC	06-08-26	18	 06-08-26 pm QSI 042	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
<del>06-08-26</del>	2							

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/09/01

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 8/24/2006 11:11:44 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 28334

Part Number: D23271

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*[Signature]* 06/09/01

Job Completion



*U86-09-01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

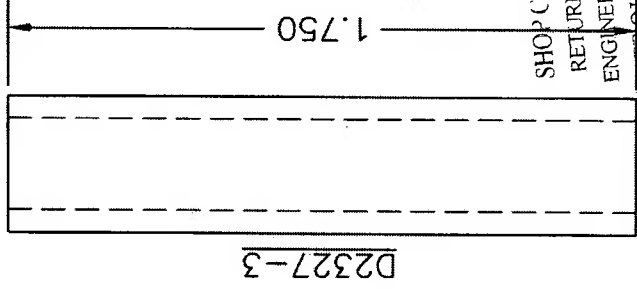
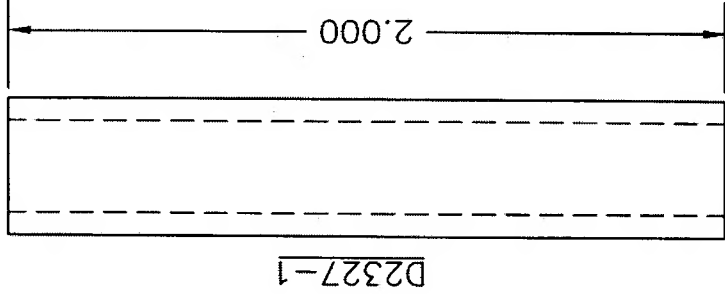
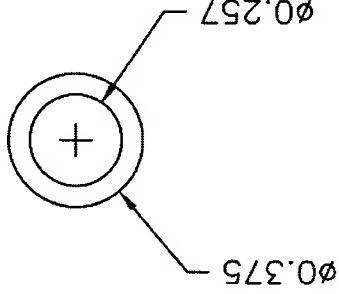
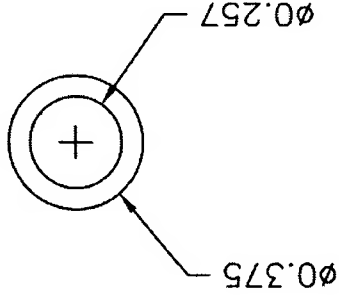
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2327	REV. C SHEET 1 OF 1
DATE 03.05.13	TITLE SPACER BUSHING		SCALE 2:1
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	

RELEASED  
03.05.21



- NOTE:
- 1) MATERIAL:  $\emptyset$ .375 AISI 303 ROUND BAR (REF DART SPEC. M303R0.375) OR  $\emptyset$ .375 AISI 304/316 SS 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.375W.065)
  - 2) FINISH: NONE
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES
  - 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28334

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.